***	- 1		
Work	Order	ID	63376

Thursday, October 28, 2010 10:21:37 AM



Page 1

Item ID:

D206-642-541

Accept

Setup Start



Revision ID:

Replacement Skidtube Item Name:

Required Date: 11/11/2010

Start Date:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: 1010.25

Date:

Tooling:

SPC (Y/N):

Date: Date: Run Start

Stop



Sequence ID/ Work Center ID

Operation Description

Revision Nbr

Set Up/ **Run Hours** Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

D3274

IIN-D206-642

D Rev M

100

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

Approval Chief Eng / Prod Mgr	Approva QC inspecto
1	
Date: _	
Date: _	
Approval	Approva
Chief Eng	QC inspecto
	Date:

Required Date: 11/11/2010

Page 2

WOLK	Order	IL	, us	53/0	
Thursday,	October	28,	2010	10:21:3	7 <i>AM</i>

Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Reg'd Qty: 1.00



Date:_____

Cust Item ID:

Customer:

Reference:

			-	
A	DD	rov	als:	:

QC:

Process Plan:

Date:

Tooling: SPC (Y/N): Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

110



Skidtubes

Skidtubes

Operation Description

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject **Qty**

Reject Insp. Number Stamp

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foilo 10 as per dwg SAD 10-11-03

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BE 10-11-04 BE 10-11-04

3- weld fwd cap as per dwg D3274 and Q\$IQQ4 AR Aluminum Rod Batch: MILLSON

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

Dart Ae	rospace	e Ltd								
W/O:		`	WORK ORDER CHANGES							t.
DATE ST	STEP		PR		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				×						
Part No	:		PAR #:	Fault Category:	NCR	: Yes	No DQ	4 :	_ Date: _	
	Res	esolution:		Disposition:	QA:	N/C C	losed:		Date: _	
		<u> </u>		WORK OPPER NON CON	FORMANIOE	/\\\	<u> </u>	 		

NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Ammassal	Approval QC Inspector					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng						
	:												
						,							
								-					
		•			1								

											
											Page 3
D206-642-54	41		Accept					Setup	Start		
Replacement S	Skidtube								Stop		
10/28/2010 11/11/2010	Start Qty: 1.00 Req'd Qty: 1.00										
Process Pla	n:	Date:	Tooling:	400	Date:	_		Run	Start		
QC:		Date:	_ SPC (Y/N):		Date:				Stop		
	Operation Description		Set Up/ Run Hours	Tool II	Tool #	Plan Code	Accept Qty				Insp. Stamp
	Chemical Conversion Coa	t per QSI005 4.1	0.00								Billo
	QC3- Inspect Part Finish Memo		0.00 S W	ulos							
•	er 28, 2010 D206-642-54 Replacement S 10/28/2010 11/11/2010 Process Pla QC:	Process Plan: QC: Operation Description Chemical Conversion Coa Memo	D206-642-541 Replacement Skidtube 10/28/2010 Start Qty: 1.00 11/11/2010 Req'd Qty: 1.00 Process Plan: Date: QC: Date: Operation Chemical Conversion Coat per QS1005 4.1 Memo	D206-642-541 Replacement Skidtube 10/28/2010 Start Qty: 1.00 11/11/2010 Req'd Qty: 1.00 Process Plan: Date: Tooling: QC: Date: SPC (Y/N): Operation Description Set Up/Run Hours Chemical Conversion Coat per QS1005 4.1 QC3- Inspect Part Finish O.00 QC3- Inspect Part Finish O.00	D206-642-541 Accept	D206-642-541 Accept	D206-642-541 Accept	D206-642-541 Accept Replacement Skidtube 10/28/2010 Start Qty: 1.00 11/11/2010 Req'd Qty: 1.00 Process Plan: Date: Date: SPC (Y/N): Date: Operation Description Chemical Conversion Coat per QS1005 4.1 O00 QC3- Inspect Part Finish O00 QC3- Inspect Part Finish O20 Accept Cust Item ID: Customer: Date: Tooling: Date: SPC (Y/N): Date: O00 Customer: Tool ID Tool # Plan Accept Code Qty Code Qty Code Qty	D206-642-541 Accept	D206-642-541 Accept Setup Start Stop Start Start Stop Start Star	D206-642-541 Replacement Skidtube 10/28/2010 Start Qty: 1.00 11/11/2010 Req'd Qty: 1.00 Cust Item ID: Customer: Process Plan: Date: Tooling: Date: SPC (Y/N): Date: Stop Operation Description Chemical Conversion Coat per QSI005 4.1 QC3- Inspect Part Finish One Cust Item ID: Customer: Run Start William Setup Stop Tool ID Tool # Plan Accept Reject Reject Number Code Qty Qty Number QC3- Inspect Part Finish One Cust Item ID: Customer: Run Start William Stop William Stop William Start William Stop William Start William Start William Start William Start William Start William Stop William Start William Star

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

S vilalor

P.....

W/O:		WORK ORDER C		f s			
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No);	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:	

Disposition:

Date: ____

QA: N/C Closed: _____

WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B		Verification	Annroyal	Annroyal		
STEP	STEP Section A		Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
	Y								
						W 7			
	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Corrective Action Section B Initial Chief Eng Chief Eng	STEP Description of NC Section A Corrective Action Section B Initial Action Description Chief Eng Chief E	STEP Section A Initial Action Description Sign & Date Section C	STEP Description of NC Section A Chief Eng Chi		

NOTE: Date & initial all entries

Resolution:

Work Orde Thursday, Octob											Page 4
Item ID: Revision ID: Item Name:	D206-642-54 Replacement S			Accept				Setup	Start Stop	1 18813127 3	
Start Date: Required Date: Reference:	10/28/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item ID	:					
Approvals:	Process Pla	n:	Date:	Tooling:	Date	:		Run	Start		
	QC:		Date:	SPC (Y/N):	Date	e:		٠	Stop		
Sequence ID/ Work Center II 150)	Operation Description Skidtubes		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accep Qty	t Re Qty	_	Reject Number	Insp. Stamp
Skidtubes Skidtubes		2-Deburr cro inside the tu	ossbolt spacer holes as pe be	0.00 It spacer holes as per Dwg D3 Tr Dwg D3274 and blow out o		\rightarrow	1			,	Biofi
		A/R□□Sika Sikaflex exp Start:□ <u>/</u> 0	~1/5 Time: 1 10/	<u>/0</u> _00 - <u>_3</u> 0 0		10	~/	1-	1	5	

160 QC

QC5- Inspect part completeness to step on W/O

Quality Control

Memo

Dart Aerospace Ltd. W/O: **WORK ORDER CHANGES Approval** Approval QC Inspector DATE STEP PROCEDURE CHANGE Ву Date Qty Chief Eng / Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ____

NCR:	-		WORK ORI	DER NON-CONFORMANCE (NCR)					
		Description of NC		Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	tion A Initial Action Description Sign & Date		Section C	Approval Chief Eng	QC Inspector		
<i>i</i> .				•					
<i>y</i>						,			
	, e ^{ee}								
,			,				<i>/</i>	:	
		,	,						

NOTE: Date & initial all entries

· AND CO

W۵	rk	O	rder	ID	633	376
YY U	I IV	\ /	ıueı	w	UJ.) / U

Page 5

Thursday, October 28, 2010;10:21:37 AM

Item ID:

D206-642-541

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Oty: 1.00

Required Date: 11/11/2010 Req'd Qty: 1.00



Date:

Cust Item ID: Customer:

Reference:

A	nr	ma	376	ls:	
A	มน	mu	va	115.	

Process Plan:

Date:

Tooling: SPC (Y/N):

Date: Date: Run

Start

Stop

Stop



Sequence ID/ Work Center ID

170



Skidtubes

Skidtubes

44.

Operation Description

QC:___

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number

Insp. Stamp

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297". Deburr

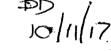
3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

BE 10/11/16



QC5- Inspect part completeness to step on W/O

180



Quality Control

Memo

Dail Ae	Tospac	e Liu								
W/O:			•	WORK ORD	ER CHANGES				•	• •
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date ,	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							!	- :		
									•	

								:		
Part No	:		PAR #:	Fault Category:	NC	R: Yes	No DQ	\:	Date: _	
	F	Resolution:		Disposition:	Q <i>A</i>	1: N/C (Closed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section B	Verification	Anneoval	Approval							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector						
ř														
*	,													
								·						
					-	,								
		,	,											

Page 6

Thurs'day, October 28, 2010 10:21:37 AM Item ID: D206-642-541 Accept Setup Start **Revision ID:** Stop Replacement Skidtube Item Name: Start Qty: 1.00 **Start Date:** 10/28/2010 **Cust Item ID: Required Date:** 11/11/2010 Req'd Qty: 1.00 **Customer:** Reference: Start Run Approvals: Process Plan: Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ **Operation** Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code **Qty Qty** Number Stamp 190 0.00 Skidtubes

Skidtubes Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use /

A/R \square Aluminum Rod \square M/1/3.65

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

200

QC5- Inspect part completeness to step on W/O

Memo

Quality Control

-unit /ioi oo puode Etu									
W/O:			WC	ORK ORDER CHANGES	3				, ,
DATE	STEP	PRO	OCEDURE CHAI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.	8 <u>.</u>	
								•	
		·							
Part No	·	PAR #:	Fault Cated	gory:	NCR: Yes	No DQ	A:	_ Date: _	<u>.</u>
	Re	esolution:	Disposition	n:	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
				Onto Ling					
								;	
	100000000000000000000000000000000000000								
						,			

Work Order ID 63376

Thursday, October 28, 2010 10:21:37 AM



Page 7

Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Otv: 1.00

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 11/11/2010

Process Plan:

Date:----

Tooling: SPC (Y/N): Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ **Work Center ID**

210

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Un/ Run Hours

Diolules

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number

Insp. Stamp

Pressure Wash per QSI005 4.3

Memo

78 10/11/23

220

HandFinish Hand Finishing

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230

Powdercoat

Powder Coating

White Gloss(Ref:4.3:5.1) per QSI005 4.3-Alum

START TIME:

OVEN TEMPERATURE: FINISH TIME:

0.00

0.00

1 101126

W/O:			WC	ORK ORDER CHANG	ES				, ,
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								·	
		· · · · · · · · · · · · · · · · · · ·							
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	4 :	Date: _	
	R	esolution:	Disposition	ı:	_ QA: N/C Cld	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
			-					,	

Page 8

Thursday, October 28, 2010 10:21:37 AM

Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Process Plan: Date: Tooling:

Date:

Run

Oty

Start

Stop



Approvals:

Date:_____

SPC (Y/N):

Date:

Code

Tool # Plan

Accept Reject

Oty

Reject Insp. Number Stamp

Sequence ID/ Work Center ID

240

QC

Quality Control

Operation **Description**

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00 => M. 10/11/29

250



Hand Finishing

HandFinishing

0.00

10/11/29

~ 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R□N/A□LPS-3□<u>N/109956</u>

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/ROSikaflex-291 DAIISII40

Sikaflex expire date:

260



Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Nut Plate & Inserts

m/ 10 11 29 (

Dart Ae	rospace	Ltd							
W/O:			WC	RK ORDER CHANG	ES			F	•
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	<u></u>
	Re	solution:	Disposition	າ:	_ QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	_ I	ion C	Chief Eng	QC Inspector

Work Order ID 63376

Thursday, October 28, 2010 10:21:37 AM



Page 9

Item ID:

D206-642-541

Accept



Setup Start



Revision ID:

Item Name:

Required Date: 11/11/2010

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run

Otv

Start

Stop



10/12/10

Tool ID

Tool # Plan

Code

Accept

Oty

Reject

Reject Insp. Number Stamp

Sequence ID/ **Work Center ID**

270



HandFinish Hand Finishing Operation Description

Memo

HAND FINISHING RESOURCE #1

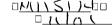
0.00

1-Install wearpads & gaskets as per Dwg D3274.

Date:

2-Install ring as per Dwg D3274

A/RUUSikaflex-291 DM(1\S\) Sikaflex expire date:



___ 3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch: \(\text{LPS-3} \)

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R \square Sikaflex-291 \square //// \square \square //// \square \square

Sikaflex expire date:

QC5- Inspect part completeness to step on W/O

280

0.00

0.00

Memo

Quality Control

-41170	ospace	Liu							
W/O:			WC	RK ORDER CHANG	ES				• • •
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·								
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	۸:	Date:	
	Re	solution:	Disposition	າ:	_ QA: N/C Cld	osed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	ANCE (NCR)			
5.475		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC inspector
					j. 				
						,			

Thursday, October 28, 2010 10:21:37 AM

Item ID:

D206-642-541

Accept



Setup Start

Stop



Revision ID: Item Name:

Replacement Skidtube

Start Date:

10/28/2010

Start Qty: 1.00

Required Date: 11/11/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Date: _____

Tooling: SPC (Y/N): Date:

Date:

Run

Start



Stop

Sequence ID/ **Work Center ID**

290

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:_

Memo

Memo

Set Up/ Run Hou

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Insp. Reject Number Stamp

B63385

300

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

U 1012.14

W/O:			WORK ORDER	CHANGES				. ',
DATE	STEP	P	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<u> </u>								
Part No	:	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	_ Date: _	
	R	esolution:	Disposition:	QA: N/C	Closed:		Date:	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)											
		Description of NC		Corrective Action Section B	Verification	Annroyal	Annroyal							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector						
					ŀ									
	a de la companya de l													
						,								

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:21:42 AM

Work Order ID: 63376

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B□05.09.23□Revised per D206-642 Rev. J□KJ/JLM

IPP Rev:C

07-02-23 Added SS Wearplates & Gaskets JLM

IPP Rev:D

replace NAS1515H3L to D3672-1 DD 07-12-06

IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC

IPP Rev:F

08-06-02

add comment DD verified by:EC

IPP Rev:G 08-10-09 revise details DD verified byEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190 Extrusion Round 3" 206	i (1888) (1818 1818) 8811 1881	Manufactured	No			110	Each	63.0000	1 	1 SAD	10	- 1]-	0.3
				` `	47575 59874	Loc	Oty 63 15 48	Loc Code		1			·
D3285-1		Manufactured	No		2 70/ 1	110	Each	141.0000		1			
					52511	<u>Loc (</u>	141 74	Loc Code			<i>a</i> .	0-10	.1 ~1
D3282-041		Manufactured	No		52647 363.	150 3 <i>90</i>	67 Each	0.0000		1		\	/1-04

W/O:			WORK ORDER (CHANGES				
DATE	STEP	PF	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,	
Part No	:	PAR #:	Fault Category:	NCR: Y	es No DQ	A:	Date: _	<u>.</u>
	Resolution		Disposition:	QA: N/C	Closed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section B		Verification	Annuaral	Ammuoval						
DATE	DATE STEP Description of N		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto						
		•												
					•									
		· · · · · · · · · · · · · · · · · · ·												
		J.												
				·		,								
•														

Thursday, October 28, 2010 10:21:42 AM

Work Order ID: 63376

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D2649

Cross Bolt Spacer

Manufactured No

Manufactured

Purchased

No

190

Each

107.0000

12

12

Loc Code

D3275-1

Crossbolt Spacer

Location	<u>L</u>	oc Oty
LG		107
58545	•	2
60652		4
61496		13
62889		88
	190	Each

216.0000

12 12

Location	Loc	Loc Oty			
LG		216			
53453		8			
61646		102			
62399		106			
	250	Each	1,874.000		



Cherry Rivet

CR3212-4-03

Location	Loc Qty	Loc Code
ST311	1874	
111359	5	
112314	2	
114436	448	
114450	71	
114859	1348	

 · ·	
XZ	

Dart Ae	rospace L	.td						
W/O:			WO	RK ORDER CHANGE	S		•	•••
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _	
	Res	olution:	Disposition: QA		QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	3)		
DATE	STEP	STEP Description of NC Section A Initial Chief Eng		Corrective Action Section	n B	Verification		Approval
				Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector
		·						

STEP Section A Initial Chief Eng Action Description Chief Eng Section C Sect

Thursday, October 28. 2010 10:21:42 AM

Work Order ID: 63376

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3415-041

Nut Plate

ALS4-1032-130

CCR264SS3-3

Cherry Rivet

Purchased

Manufactured

No

No

250

Each

52.0000

Location Loc Oty ST056 52 _33842 52

250 Each

Loc Qty

416

44

368

Each

416.0000

Loc Code

Il jolilza

Location ST311 No

112314 113539 113973 250

2,653.000

Loc Code

Loc Code

78

10/11/29

Purchased Insert

Location	Loc Oty				
PKG11	886				
114723	886				
ST282	1728				
110511	10				
115911	1718				
ST381	39				
114654	39				

M116049

W/O:			WORK ORDER CHANGES						
DATE	STEP	PR	В	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		· · · · · · · · · · · · · · · · · · ·							
Part No	:	PAR #:	Fault Category:	NCR:	Yes	No DQA	۸:	_ Date: _	
	Resolution:		Disposition:	QA: 1	wc c	losed:		Date:	·

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification		Annessal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
					1			
				· •				
		·			. ,			
,								

Thursday, October 28, 2010 10:21:42 AM

Work Order ID: 63376 Parent Item: D206-642-541 Replacement Skidtube Parent Item Name: D3536-15 Gasket

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

Each 18.0000

Location FP 56055 60875 FP11

12 59238 62459 11 270 Each

270

3.0000

Loc Code B 6 3568

D3536-23

Gasket

Location FP011

61237

Loc Qty 3 Each

Loc Qty

Loc Code B63570

D3536-35

D3536-39

Manufactured No

Manufactured

Manufactured

No

No

270

16.0000

10/12/09

Gasket

Manufactured No

Loc Qty B63579 Location FP012 16 58683 1 61692 3 62462 12 270 Each 12.0000

Gasket

Location Loc Qty FP12 12 58215 1 58571 11 Loc Code 1363578

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROC	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
				·								
						<u> </u>						
Part No		PAR #:	_ Fault Category:	NCR: Yes	No DQ	A:	Date:	<u> </u>				

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	A	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
<u>.</u>											

Thursday, October 28, 2010 10:21:43 AM

Work Order ID: 63376 Parent Item:

D3535-35

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-15

Wearshoe

Manufactured No

No

No

Manufactured

Manufactured

270

Each

22

3

13

6

12

8

Each

Each

22.0000

Loc Code B63569

Location Loc Qty FP18 61241 62241 62707

270

26.0000

10/17/09

Wearshoe

Loc Qty Location FP018 26 60865 62461 62969 270

Loc Code

27.0000

W 10/2/09

D3535-39 Wearshoe

Location Loc Qty Loc Code FP18 27 60233 16 62945 11

Duit Ac	ospace	Liu							
W/O:			WO	RK ORDER CHANG	ES				•9
DATE	STEP	PR	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date: _	
Resolution:			Disposition: QA			QA: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NC	R)			
	<u>-</u>	Description of NC	Corrective Action Se		Section B		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	Verification Section C	Approval Chief Eng	QC Inspector
<u>.</u>									
						l			

Thursday, October 28, 2010 10:21:43 AM

Work Order ID: 63376 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube Required Date: 11/11/2010 **Start Date: 10/28/2010** Start Qty: 1.00 Required Qty: 1.00 D3535-23 Manufactured No 270 Each 28.0000 Wearshoe Location Loc Qty Loc Code FP 61830 6 FP021 21 60231 8 62706 13 D3537-3 270 Manufactured No Each 40.0000 10/12/10 Wearpad Location Loc Qty Loc Code FP17 40 60866 3 61674 17 62705 20 D3537-1 Manufactured No 270 Each 66.0000 Ml 10/12/10 Wearpad Loc Qty Location Loc Code B63545 FP 55465 FP017 59 61986 15 62209 44 FP17 6

57713

60491

3

W/O:		WORK ORDER C	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC'Inspector		
							-		
Part No		PAR #· Fault Category:	NCR: Yes	No DO	A.	Date:			

Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

•	WORK ORDER NON-CONFORMANCE (NCR)									
	Description of NC		Corrective Action Section B			Approval	Ammerical			
STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
				•						
				: :	,					
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Description			

Thursday, October 28, 2010 10:21:43 AM

Work Order ID: 63376

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



107534

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332 Purchased

No

270

Each 29.0000

80 80

washer

AN960C416

NAS1149C0463 Purchased

No

Loc Oty

270

270

29 29

Each

Loc Code

M115832 30.0000

OFX

washer

D3672-1

Manufactured No ST346

Location

Location

Location

ST245

100993

Loc Qty 30 30

Loc Qty

Loc Code

M115358 847.0000

Il volizio

10/17/16

Loc Code

Phenolic Washer

ST077 847 42329 52505

150 697

Each

Thursday, October 28, 2010 10:21:43 AM

W/O:	- Iospace L		WORK ORDER (CHANGES				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval , QC Inspector
								,
Part No	:	PAR	#: Fault Category:	NCR: Yes	No DQ	A:	Date: _	
	Reso	olution:	Disposition:	QA: N/C C	losed:		Date:	

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification		Ī
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
. L								
						,		

Picklist Print

Page 8

Thursday, October 28, 2010 10:21:43 AM

Work Order ID: 63376 Parent Item: D206-642-541 Parent Item Name: Replacement Skidtube Required Date: 11/11/2010 Start Date: 10/28/2010 Start Qty: 1.00 Required Qty: 1.00 AN3C4A Purchased No 270 Each 2,233.000 80 **BOLT** Location Loc Qty Loc Code ST303 3 115438 ST350 2230 114108 14 114416 12 114523 2 115300 202 115589 1000 115936 1000 AN4C5A Purchased No 270 Each 481.0000 10/12/16 **BOLT** Location Loc Qty Loc Code ST346 481 110552 112243 477 D2646 Manufactured No 270 45.0000 Each Aft Cap Location Loc Qty Loc Code FP-4 35 573<u>32</u> 35 fp5 62652 FP6 52663

	rospace Ltd							
W/O:			WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE			y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								. }
Part No	:	PAR #:	Fault Category:	NCR:	Yes No D	QA:	Date: _	
	Resolution:		Disposition:	QA: N	C Closed: _	·· · · · · · · · · · · · · · · · · · ·	Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
5.475		Description of NC	Corrective Action Section B		Verification Appr	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto			
					·						
	:										
						,					
							:				

Picklist Print

Thursday, October 28, 2010 10:21:43 AM

Work Order ID: 63376

Parent Item:

D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 10/28/2010

Required Date: 11/11/2010

Page 9

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured

No

270

Each

23.0000

Hl 10/12/10

Ring

Location	Loc Qty
ST473	23
51586	1
53446	7
61322	15

1362961

W/O:			WC	RK ORDER CHANG	GES					•
DATE	STEP	PR		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									·	
Part No	:	PAR #:	Fault Categ	jory:	NCR:	Yes I	No DQ	A:	Date: _	
	Reso	olution:	Disposition	ı:	QA: I	WC Clo	sed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
DATE	CTED	Description of NC	escription of NC Corrective Action Sec				Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
					ŀ			:		
							_			
ž .										
							,			



DESIG	CP.	DRAWN BY	DART AEROSPACE USA, INC.
CHEC	KED 1	APPROVED #	DRAWING NO. REV. D
L	#	一件	D3274 SHEET 1 OF 4
DATE			TITLE SCALE
06.	12.19		SKIDTUBE ASSEMBLY NTS
Α		04.03.15	NEW ISSUE
В		04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
С		05.03.16	ADD -043; NEW INSERTS
D		06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

	<i></i>			
	Qty -041	Qty -043	Part Number	Description
	X		D3274-041	SKIDTUBE ASSEMBLY
		Х	D3274-043	SKIDTUBE ASSEMBLY
	1	1	D2600-1-240	EXTRUSION
	1	1	D2646	AFT CAP
	12	12	D2649	CROSS BOLT SPACER
	12	37	D3275-1	CROSS BOLT SPACER
CITOD CONU	1	1	D3282-041	FLOAT WEB
SHOP COPY	1	1	D3285-1	CAP
RETURN TO	1	1	D3413-1	RING
ENGINEERING	1	1	D3415-041	NUT PLATE
UNCONTROLLED COPY	. 1	1	D3535-15	WEARSHOE
3		_ 1	D3535-23	WEARSHOE
SUBJECT TO AMENDMENT	1	1	D3535-35	WEARSHOE
TTHOUT NOTICE	1	1	D3535-39	WEARSHOE
WORK ORDER	1	1	D3536-15	GASKET
NO. 23376	1	1	D3536-23	GASKET
\(\frac{1}{\sqrt{1}}\)	_1_	1	D3536-35	GASKET
	1	1	D3536-39	GASKET
KX/0-10-28	9	9	D3537-1	WEARPAD
	1	1	D3537-3	WEARPAD
	78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
	80	80	AN3C4A	BOLT
	1	1	AN4C5A	BOLT
	1	1	AN960C416	WASHER
l	80	80	AN960C10L	WASHER
. [2	2	CCR264SS3-3	RIVET
1	2	2	CR3212-4-03	RIVET
	2	2	NAS1515H3L	WASHER

GENERAL NOTES:

- 1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2. DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 3. ALL HOLES DRILLED ON CENTERLINES.
- 4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 5. WELDING TO BE DONE PER DART QSI 004.
- 6. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

Copyright @ 2004 by DART AEROSPACE USA, INC.

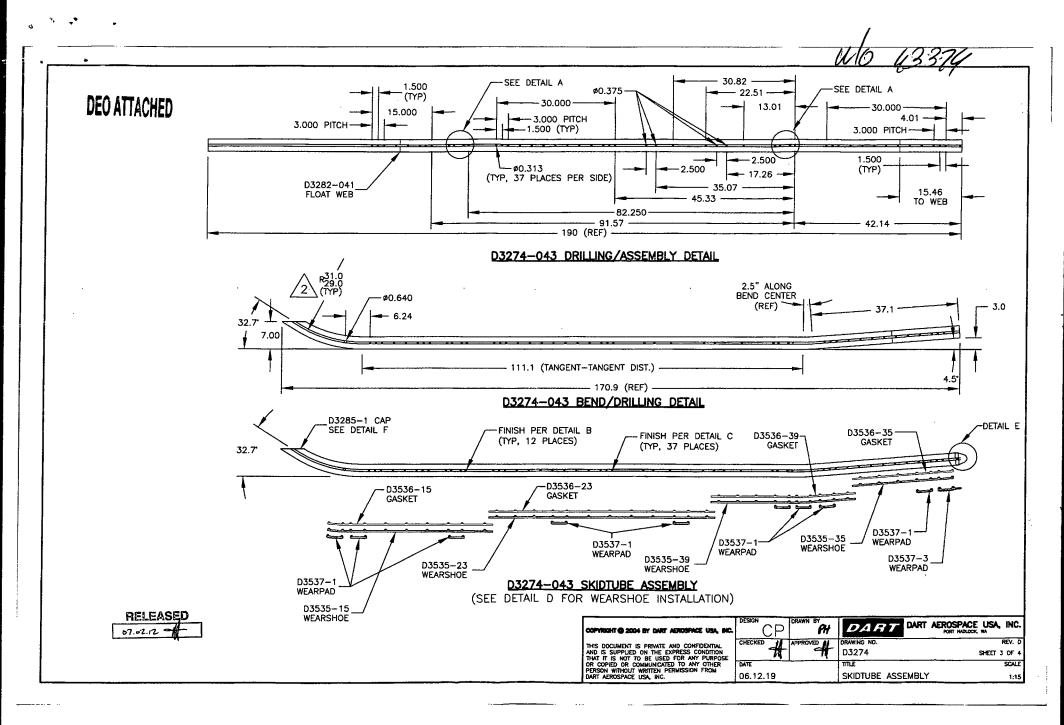
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:	.,		V	VORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							Prod Mgr	· · · · · · · · · · · · · · · · · · ·	
	,								
								-	
						. *			
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA :	Date:		
	R	esolution:	Disposit	ion:	_ QA: N/C Cld	sed:	Date: _		
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCR)			
DATE	Description of NC Corrective Action Section B					Verification Approval Appro			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
	-								
						,			
· •									
		1	1		1	į.	1	1	

NOTE: Date & initial all entries

SEE DETAIL A 30.82 DEO ATTACHED -SEE DETAIL A ø0.375-- 22.51 13.01 30.000-12.000 -30.000 4.01 ~ 6.000 -15.000 15.000 U− Ø0.313 (TYP, 12 PLACES PER SIDE) 2.500 D3282-041 FLOAT WEB 35.07 15.46 45.33 -TO WEB 82.250 - 94.57 -42.14 190 (REF) -D3274-041 DRILLING/ASSEMBLY DETAIL 2.5" ALONG BEND CENTER Ø0.640 (REF) - 3.0 32.7 7.00 111.1 (TANGENT-TANGENT DIST.) 4.5 - 170.9 (REF) D3274-041 BEND/DRILLING DETAIL -DETAIL E D3285-1 CAP SEE DETAIL F FINISH PER DETAIL B -D3536-39 D3536-35-GASKET FINISH PER DETAIL C (TYP, 12 PLACES) GASKET (TYP, 12 PLACES) 32.7 -D3536-23 GASKET D3536-15 GASKET D3537-1 D3535~35 WEARSHOE WEARPAD D3537-1 WEARPAD D3537-1 WEARPAD D3535-39 WEARSHOE D3537-3 WEARPAD D3535-23 WEARSHOE D3537-1 WEARPAD D3274-041 SKIDTUBE ASSEMBLY (SEE DETAIL D FOR WEARSHOE INSTALLATION) D3535-15 WEARSHOE RELEASED DART AEROSPACE USA, INC. DART CP 07.02.12 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. D3274 SHEET 2 OF 4 DATE SCALE 06.12.19 SKIDTUBE ASSEMBLY 1:15

Dail Ac	i ospace i	Liu							
W/O:			WO	RK ORDER CHANGI	ES				1
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						<u>. </u>			
Part No		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
	Res	solution:	Disposition	:	QA: N/C	Closed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section	on B	Vorifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	Verification Section C		Approval QC Inspector
	1								



W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CHA	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector						
				·									
													
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA :	Date: _						
	R	esolution:	Disposition	າ:	_ QA: N/C Clo	osed:	Date: _						
NCR:		V	WORK ORDI	ER NON-CONFORMA	NCE (NCR)							
DATE	STEP	Description of NC		Corrective Action Section		Verification	n Approval	Approval					
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					
		!	1										

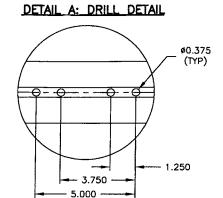
CHAMFER 0.030x45*

SCALE

(TYP)

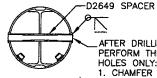
SKIDTUBE ASSEMBLY

06,12,19



TO 0.75 DEPTH AND 0.070 WALL

DETAIL B FOR Ø0.375 HOLES ONLY

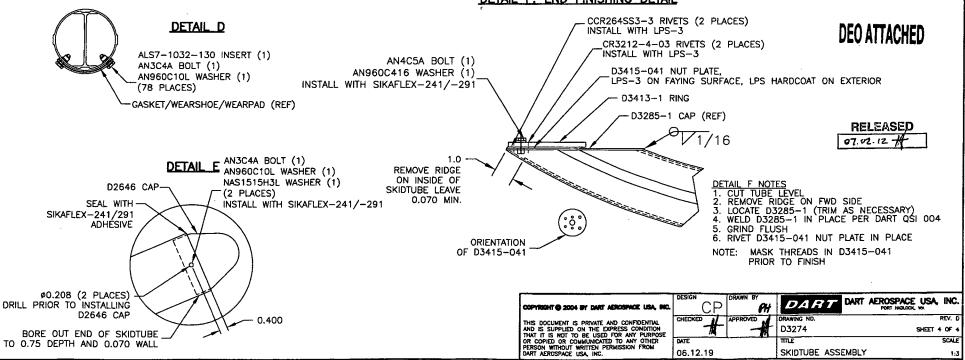


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

- 1. CHAMFER HOLE 0.030x45° 2. INSERT D2649 SPACER
- 3. WELD INTO PLACE AND GRIND FLUSH
- 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL_C FOR Ø0.313 HOLES ONLY -D3275-1 SPACER

DETAIL F: END FINISHING DETAIL



W/O:			W	ORK ORDER CHANG	ES				() ************************************
DATE	STEP		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector		
				•			-		
Part No	:	PAR #: _	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date:	
	R	Resolution:	Dispositi	on:	_ QA: N/C CI	osed:	·	Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	OTED	Description of NC		Corrective Action Section		Verifi	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector

#/ ep. 5	á										
	DRAWING N	٧٥.	TITLE		, REV. D C	ART AEROS	SPACE USA, II	NC D.E.O. NO.		SHEET NO.	SCALE
	D3274		SKIDTUBE	ASSEMBLY		ENGINEE	RING ORDER	D3274-D-1	\cap	SHEET 1 OF 1	NTS
•	DŘAWN	S		CHECKED	Ja .	MFG. APPR.	d	APPROVED	MP,	DE APPR.	
	DATE	09.06.	17	DATE 09.0	06-23	DATE 59/6	c /23	DATE	09/06/23	DATE 09.06.23	

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

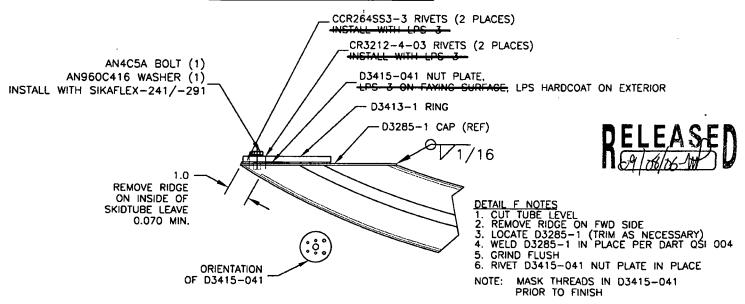
AMEND NOTE 8: "SPRAY INSIDE OF TUBE WITH A COAT-OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS:

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

w/o 43374

DETAIL F: END FINISHING DETAIL



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DATA REROSPACE USA, INC.

Dart Aerospace Ltd	Aerospace Ltd	נ
--------------------	---------------	---

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva! QC Inspector				
						,					

Part No:		PAR #:	Fault Categor	· 'Y:		NCR: Yes No	DQA:	Date:
	. *	Resolution:	Disposition: _		1 .	QA: N/C Close	ed:	Date:

NCR:		W	ORK OR	DER NON-CONFORMANCI	E (NCR)			
	STEP	Description of NC Section A	Corrective Action Section B			Verification	Approval	Annroyal
DATE			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
	*							
	7, 1h			<i></i>			• î.* •	
	* * *		* '			` ` `		
		The state of the s						
		*			·			
#- 1			·**	3		•	* ,	
							·	
						# #		
			j j		3	**		

NO. 241

AWS D17.1.2001 QUALIFICATION TEST RECORD

TEST REQUIREMENTS AND RESULTS

Visual:	pass[i] fail[]
Penetration:	pass[] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier De De La Contraction	Date of Test Coupon 10.09.30 Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.